

Work Order ID 86233

86233

Page 1

June-25-12 10:31:42 AM

Item ID: D3564-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 25/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/25

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 Dwg Rev: 0 Prog Rev: 0 2-
Deburr if necessary

20 0 Jm 12-7-4

304 .063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 Jm 12-7-4

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

81210765

caules
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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June-25-12 10:31:42 AM

Item ID: D3564-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 25/06/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/07/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* Brake NC	NC BRAKE	0.00				20			12/07/23
Brake NC	Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179	0.00							

140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				(20)			
Quality Control	Memo	0.00							

150 *150* Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				20X			12/07/24
Powder Coating	Memo START TIME: 11:50 OVEN TEMPERATURE: FINISH TIME: 12:20	0.00							

M121279

3200F

12:20

W/O:		WORK ORDER CHANGES					
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Page 3

June-25-12 10:31:42 AM

Item ID: D3564-13

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Wearshoe

Stop

NS2

Start Date: 25/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

20 0 BL 12.7.24

170

Identify as per dwg & Stock Location: FR2

0.00

170

Packaging

Memo

0.00

Packaging

20 0 BL 12.7.24

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/07/25
MLJ 12/07/25

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NOTE: Date & initial all entries

Picklist Print

June-25-12 10:31:46 AM

Page 1

Work Order ID: 86233

86233

Parent Item: D3564-13

D3564-13

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ
 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	1.5746	0.222	4.673684			

M304S16GA

304/316 Sheet .063

**

Jm 12-7-4

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

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NOTE: Date & initial all entries



07.09.04

12/06/25

INDEX REVIEW

~~First change~~

OK 4/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

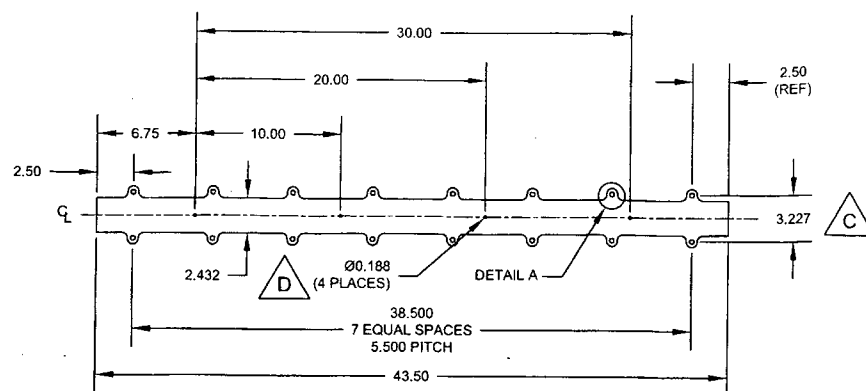
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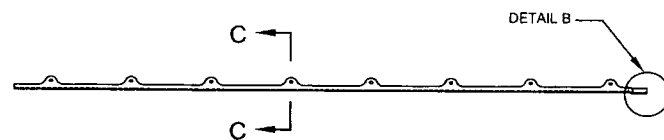
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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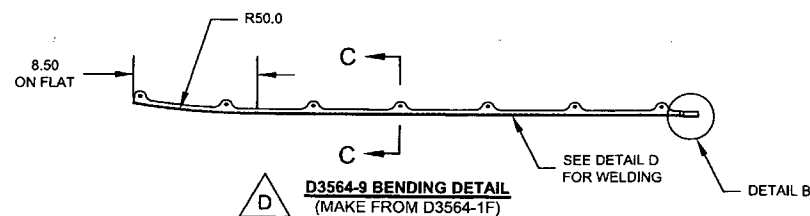
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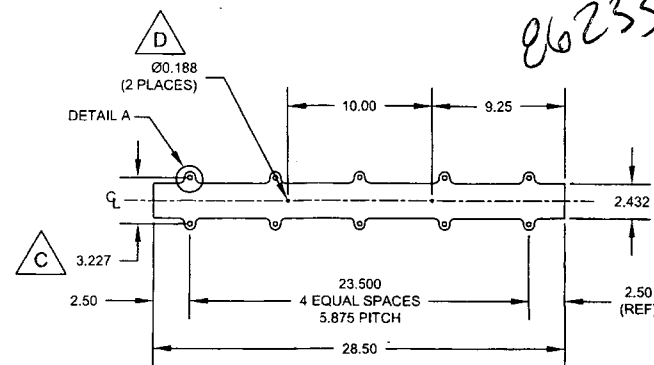
D3564-5F FLAT PATTERN



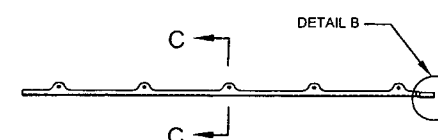
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



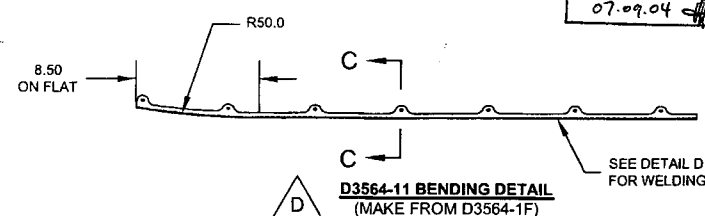
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED
07.09.04

UNDER REVIEW
OK 07.11.04
OK 07.11.04

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MFG. APPR.	PH	D3564	SHEET 2 OF 3
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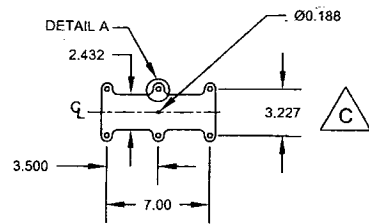
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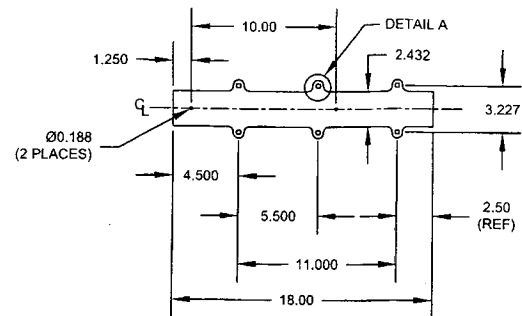
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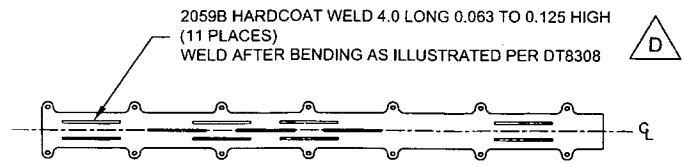
NOTE: Date & initial all entries



D3564-13F FLAT PATTERN

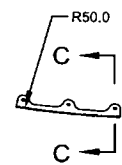


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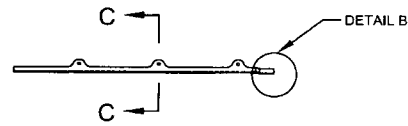


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

86233

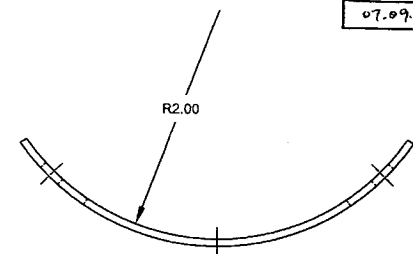


D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



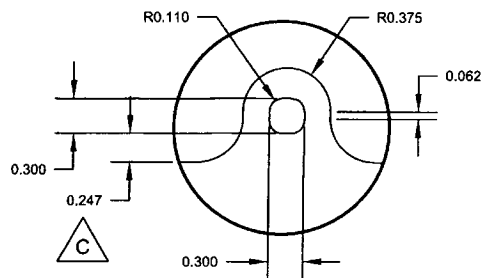
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

RELEASED
07.09.04

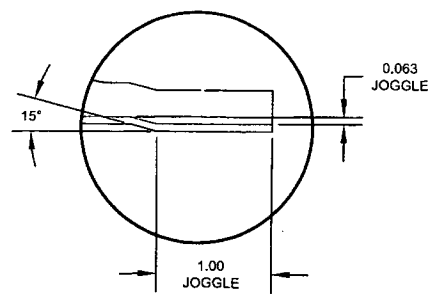


SECTION C-C
SCALE 1:1

UNDER REVIEW
14
OK 07.11.28



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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